

Work Order ID 53815-1

November 18, 2009 2:21:32 PM

split 1



Page 1

Item ID: D4010-041

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Assembly

Stop



Start Date: 11/18/2009 Start Qty: 18.00

Required Date: 11/19/2009 Req'd Qty: 18.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *WVF*

Date: *09-11-19* Tooling:

Date:

Run Start

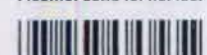


QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4010-041	C
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100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

110

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Use wearplate jig DT9542 to transfer drill holes in bearpaw as per dwg and use 0.375" unibite to open holes to finish size.

2- Use wearbar to transfer drill hole and open to finish size as per dwg

3- Deburr

4- Assemble as per Dwg D4010

of 09/11/23

P70

BB 09/11/23
(84)

W/O: 53815		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/11/24	110.	Remove step 1 on SER 110 on this w/o - was already done on D4010-1 w/o .53816 Routings to be corrected	Wk	09/11/24	4.	J 09/11/24	S 09/11/24

Part No: D4010-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53815

November 18, 2009 2:21:32 PM



Page 2

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Stop



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Cust Item ID:

Required Date: 11/19/2009 Req'd Qty: 18.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Memo

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

BB 09/11/24
XY

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 S octul24

000

140



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

PP053961

09/11/24 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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November 18, 2009 2:21:32 PM



Page 3

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Setup Start



Revision ID:

Item Name: Bearpaw Assembly

Stop



Start Date: 11/18/2009 Start Qty: 18.00



Cust Item ID:

Required Date: 11/19/2009 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/24 [Signature]

UMF 09-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

November 18, 2009 2:21:31 PM

Page 1

Work Order ID: 53815



Parent Item: D4010-041



Parent Item Name: Bearpaw Assembly

Start Date: 11/18/2009

Required Date: 11/19/2009

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.
DL. Verified by:DD IPP Rev. C Dwg.
Redesign 09/11012 DL VERIFIED BY:DD

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ AN3CSA	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 1,132.000	Remaining 90.0000	Qty	Date	Status
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1132	
111424	8	
111707	69	
112314	1	
112641	454	
113121	300	
113149	300	

D3456-1RevA



Washer

Manufactured No

100 Each 155.0000 54.0000



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG	7	
25701	7	

Main Warehouse

ST	148	
51653	148	

D4010-1



Bearpaw

Manufactured No

100 Each 0.0000 18.0000



20 OK 09/14/23

12 OK 09/14/23

30 09/14/24

53816 X 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 18, 2009 2:21:31 PM

Work Order ID: 53815



Parent Item: D4010-041



Parent Item Name: Bearpaw Assembly

Start Date: 11/18/2009

Required Date: 11/19/2009

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.
DL. Verified by:DD
Redesign 09/11012 DL VERIFIED BY:DD
IPP Rev. C Dwg.

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D4013-041		Manufactured	No			100	Each	0.0000	18.0000			
Wearplate Assembly												
D4015-041		Manufactured	No			100	Each	22.0000	90.0000			
Wearbar Weldment												

53825
BB 09/11/2004

Warehouse	Loc Qty	Loc Code
Location		
HONG KONG		
ST	22	

53815
BB 09/11/2004

MS21043-3



Nut

Purchased No 100 Each 4,841.000 90.0000



Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	4761	
111819	78	
112243	39	
112314	4644	

20 WH 09/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 53815

Parent Item: D4010-041

Parent Item Name: Bearpaw Assembly


Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.
DL. Verified by:DD IPP Rev, C Dwg.
Redesign 09/11012 DL VERIFIED BY:DD

Start Date: 11/18/2009

Required Date: 11/19/2009

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21043-4		Purchased	No			100	Each	1,341.000	54.0000			
												
Nut												

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1301	
112243	2	
112314	499	
112492	300	
113064	500	

12 DL 02/11/23

November 18, 2009 2:21:32 PM

Shop Packet Print

Page 3

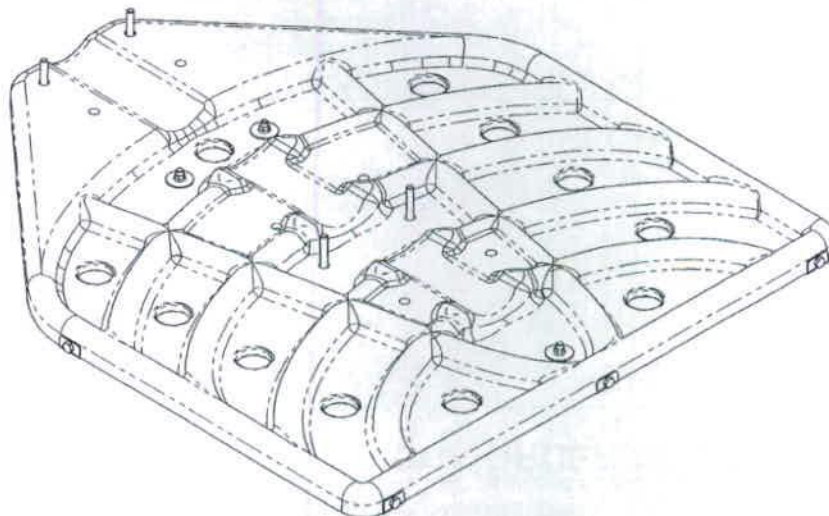
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4010-041 BEARPAW ASSEMBLY (407)

C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED, ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES, REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4010	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BEARPAW (407)	NTS
DATE	09.11.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE ASSUMPTION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

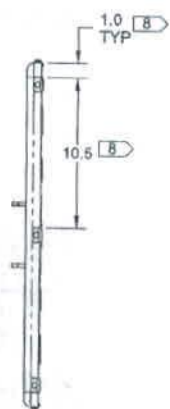
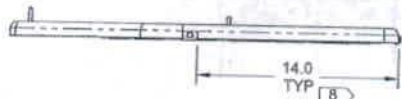
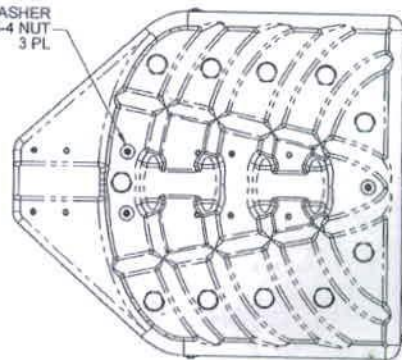
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

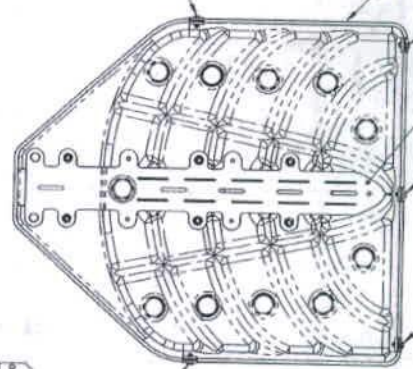
NOTE: Date & initial all entries

D3456-1 WASHER
MS21043-4 NUT
3 PL



#53815

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-1
BEARPAW

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
3	3	D3456-1	WASHER
4	1	D4010-1	BEARPAW
5	1	D4013-041	WEARPLATE ASSEMBLY
6	5	D4015-041	WEARBAR
21	5	AN3C5A	BOLT
22	5	MS21043-3	NUT
23	3	MS21043-4	NUT

D4010-041 NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.41 lbs
- 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL $\varnothing 0.191$ HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN	LA	DART AEROSPACE LTD	
DRAWN	LA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4010	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BEARPAW (407)	NTS
DATE	09.11.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

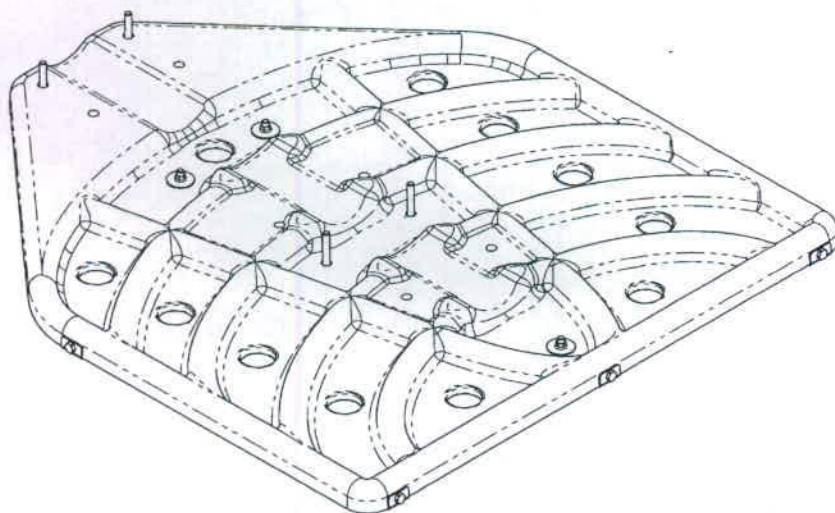
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4010-041 BEARPAW ASSEMBLY (407)

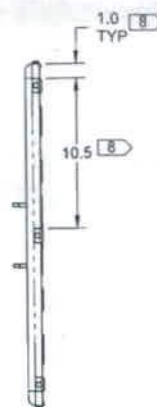
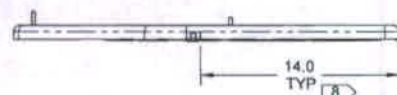
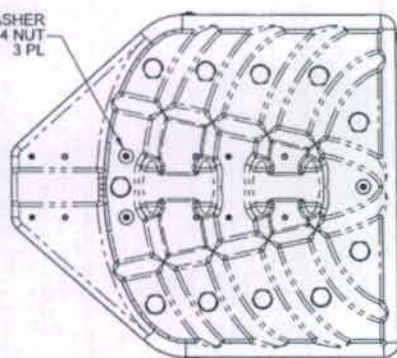
53815

RELEASED
2009-11-21
MB

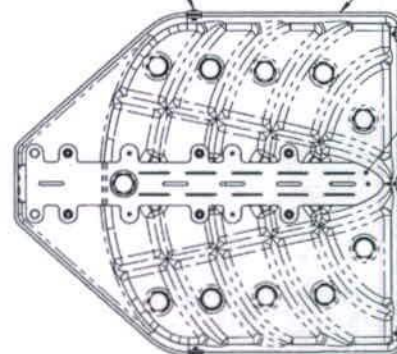
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B	REDESIGNED, ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4010	REV. C SHEET 1 OF 3
TITLE BEARPAW (407)	SCALE NTS
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D3456-1 WASHER
MS21043-4 NUT
3 PL



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-1
BEARPAW

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
3	3	D3456-1	WASHER
4	1	D4010-1	BEARPAW
5	1	D4013-041	WEARPLATE ASSEMBLY
6	5	D4015-041	WEARBAR
21	5	AN3C5A	BOLT
22	5	MS21043-3	NUT
23	3	MS21043-4	NUT

D4010-041 NOTES:

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- 2) FINISH: N/A
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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A/S	DRAWING NO.	REV. C
MFG. APPR.	D	D4010	SHEET 2 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	#	BEARPAW (407)	NTS
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RELEASED
2009-11-24

53815

